

Date: Monday, 10/30/2006 4:15:10 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 29229  
 Estimate Number : 10482  
 P.O. Number : N/A  
 This Issue : 10/30/2006 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : MA Type : LANDING GEAR  
 Previous Run : 28696  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]* 061031  
 Comment : Est. B 02.07.26 Updated Location RF

Drawing Name : WEB  
 Part Number : D2923  
 Drawing Number : D2923 REV.A  
 Project Number : N/A  
 Drawing Revision : A  
 Material : N/A  
 Due Date : 11/20/2006

Qty: 9 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26005108 Extrusion 'I Beam' thin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 D2600-5-108 Extrusion 'I Beam' thin  
 Batch: B24410 m-h 06/11/02

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1  
 Cut D2600-5 Extrusion to length as per Dwg D2923.  
 Deburr ends

m-h 06/11/03 (9)

3.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1  
 1- Drill pilot holes in web as per Dwg D2923 using drill jig DT8481  
 2- Open holes to finish size as per Dwg D2923.  
 3- Deburr

m-h 06/11/03 (9)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 6-11-3

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

m-h 06/11/03 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DE Date: 06/11/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 10/30/2006 4:15:10 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 29229

Part Number: D2923

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*pmc 06-11-8 (9)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *LLG*

*pmc 06-11-8 (9)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(9) 06/11/08*

Job Completion



*06/11/08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

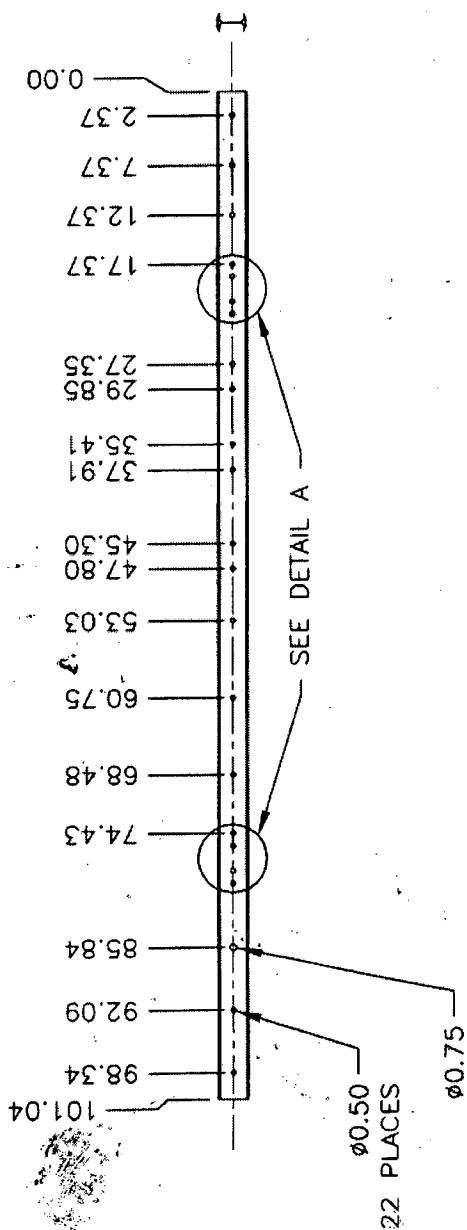
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

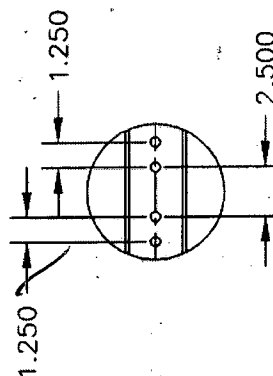


DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED 	APPROVED 	DRAWING NO. D2923	REV. A SHEET 1 OF 1
DATE 99.10.14	TITLE WEB		SCALE 1:18
A	99.10.14	NEW ISSUE	

RELEASED  
00.05.11



DETAIL A  
SCALE 1:9



MAKE FROM D2600-5 EXTRUSION  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29229

